

Date: Friday, 09/03/2007 10:24:05 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT TUBE ASSEMBLY
Job Number : 31153	
Estimate Number : 10699	
P.O. Number : <i>N/A</i>	Part Number : D3391025
This Issue : 09/03/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3391 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : E
Previous Run : 30934	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 30/03/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev: B 06-02-07 ECN773 dwg rev. D EC Est Rev: C 06-03-28 Update Manufacturing Instructions JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6014090	ALUMINUM EXTRUSION
-----	----------	--------------------



Comment: Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty	Part Number	Description	Batch
1	D6014-090	Extrusion	<i>B26546</i>

Identify as D3391-3

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: *AA* & Dwg D3391 Rev: *E*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS

1-Machine as per Folio FA 599 Rev: *AA* & Dwg D3391 Rev: *E*

2-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

3-Deburr

gmk 07/03/18

①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng		Action Description Chief Eng			

NOTE: Date & initial all entries

Date: Friday, 09/03/2007 10:24:05 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 31153

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 07/03/18

①

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 07/03/20 (X1)

7.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

EL 7-3-28

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-3-28

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill Tube as per D3391 using DT8809 (HOLES MARKED "A" ONLY)

3-Drill and c' sink wearshoe holes as per Dwg D3391 Using DT8878(Mid Tube) & DT8217 Wearplate Jig

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391

5-Deburr

Tools: rill

DP 7-4-12

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 07-04-12 ①

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

DP 07-04-12 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 31153

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

POWDER COATING

POWDER COATING



M103706



①

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-l

07/04/12

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

25 07-04-12

14.0

NAS1330C3KB166

INSERT



①

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

INSERT

Pick:

Qty

Part Number

Description

Batch

8

NAS1330C3KB166

Insert

M103278 m-l 07/04/12

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



①

Comment: HAND FINISHING RESOURCE #1

Install Inserts as per dwg

m-l

07/04/12

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/13

①

17.0

AESS10KB366

INSERT



①

Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Insert

Pick:

Qty

Part Number

Description

Batch

14

AESS10KB366 Insert

M103758 m-l 07/04/12

18.0

AESS10KB266

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty

Part Number

Description

Batch

2

AESS10KB266

Insert

or NAS1330C3KB266

M17905 m-l 07/04/12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/03/2007 10:24:06 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 31153

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AESS10KB316

INSERT



①

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
INSERT

Pick:

Qty	Part Number	Description	Batch
2	AESS10KB316	Insert	M17905
	or NAS1330C3KB316		

m.l 07/04/12

20.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Aft Cap

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	B30119

B30119

21.0

AN3C4A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C4A	Bolt	M103691

M103691

22.0

AN960C10L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Inventory

Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	M103691

M103691

23.0

NAS1515H3L

WASHER,



①

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
WASHER

Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3L	Washer	M103641

M103641

m.l 07/04/13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 01/04/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 31153

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



①

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291

Sikaflex expiry date:

M103497
07-10

M.R 07/04/13

25.0

QC5

INSPECT WORK TO CURRENT STEP



2004.16 ①

Comment: INSPECT WORK TO CURRENT STEP

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

see 31709A

27.0

QC21

FINAL INSPECTION/W/O RELEASE



d.

Comment: FINAL INSPECTION/W/O RELEASE

2007/04/16

Job Completion



W 0704.16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng		Action Description Chief Eng			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	3153
Description: Float Skidtube (412)		Part Number:	D3391-3
Inspection Dwg: D3391 Rev: E		Page 1 of 1	

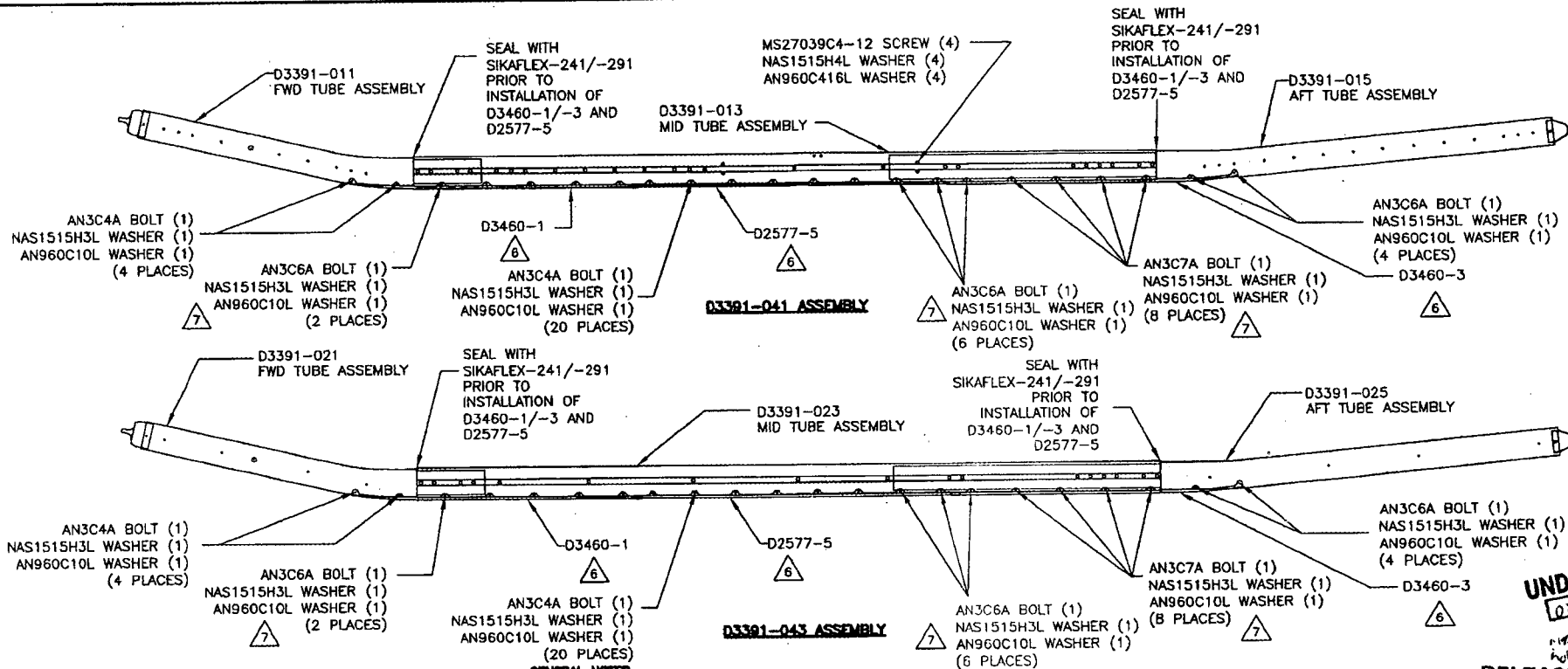
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.500	✓			
88.93	+/-0.030	88.93	✓			
44.995	+/-0.030	45.00	✓			
3.200	+/-0.010	3.208	✓			
1.526	+0.000/-0.030	1.520	✓			
0.200	+/-0.010	0.197	✓			
7.500	+/-0.010	7.497	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
0.400	+/-0.010					
Ø0.208	+0.005/-0.001					
3.300	+/-0.010	3.307	✓			
0.200	+/-0.010	0.197	✓			
3.520	+/-0.010	3.510	✓			
0.687	+0.010/-0.000	0.691	✓			
R0.062	+/-0.010	R0.062	✓			
Ø0.484	+0.005/-0.001	Ø0.485	✓			

Measured by: J.F. / 130/12	Audited by: J.L.	Prototype Approval:	N/A
Date: 07/03/09	Date: 07/03/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	



D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	NAS1515H3L	WASHER
44	44	AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
1	1	D2577-5	WEARSHOE
1	1	D3460-1	WEARSHOE
1	1	D3460-3	WEARSHOE

- GENERAL NOTES**
- ALL DIMENSIONS ARE IN INCHES
 - TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - FINISH: ACID ETCH AND ALDINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCOY" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
 - USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL "E" SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS. C/SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.
 - APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES
 - DO NOT TORQUE, HAND TIGHTEN ONLY

UNDER REVIEW
06.05.03

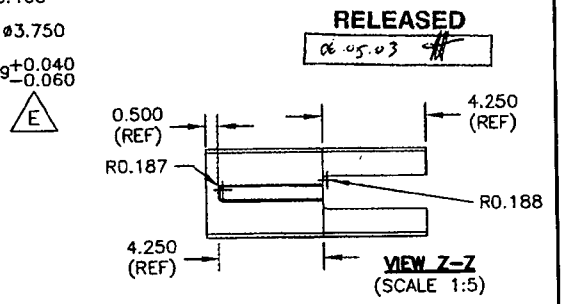
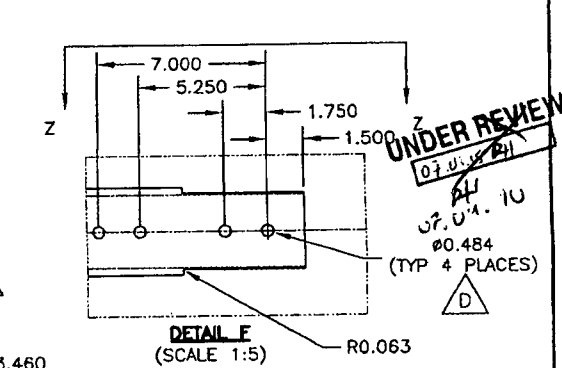
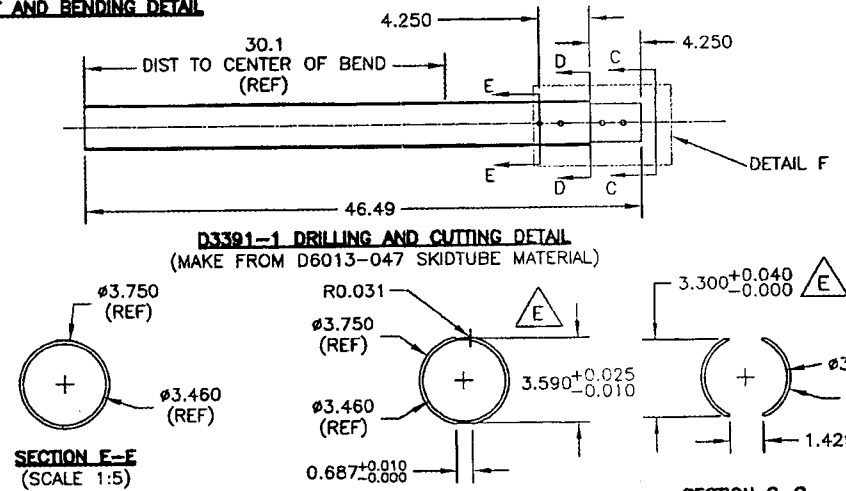
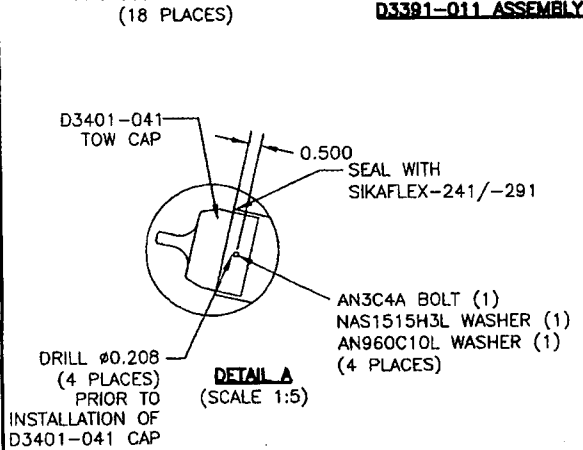
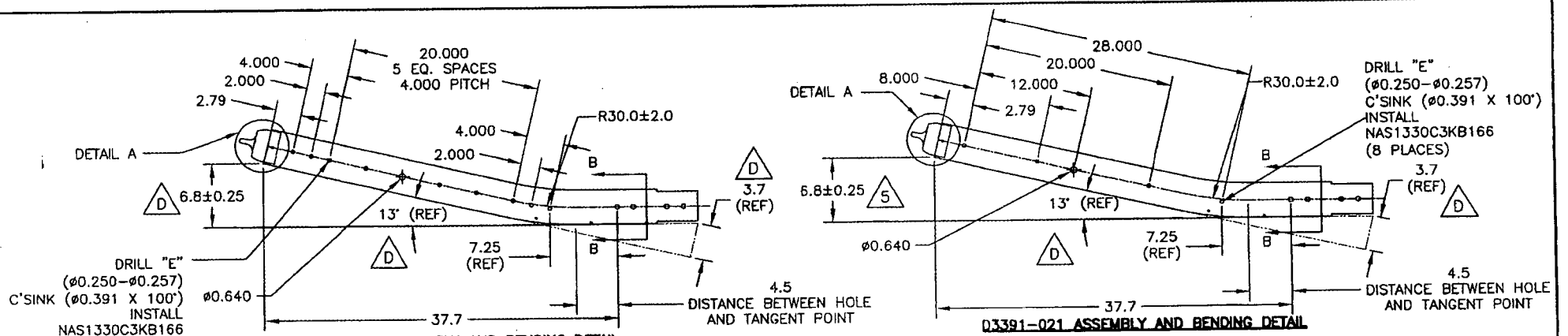
RELEASED

E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	06.04.25	TITLE
		412 FLOAT SKIDTUBE

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DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

REV. E
SHEET 1 OF 5
SCALE
NTS

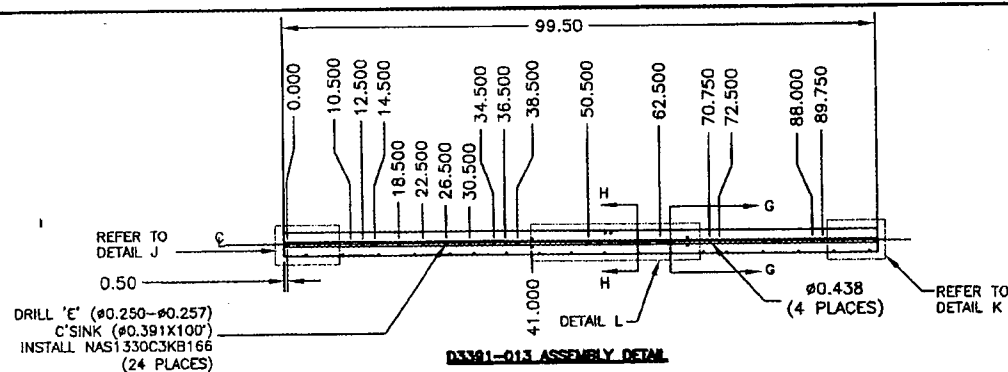


D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

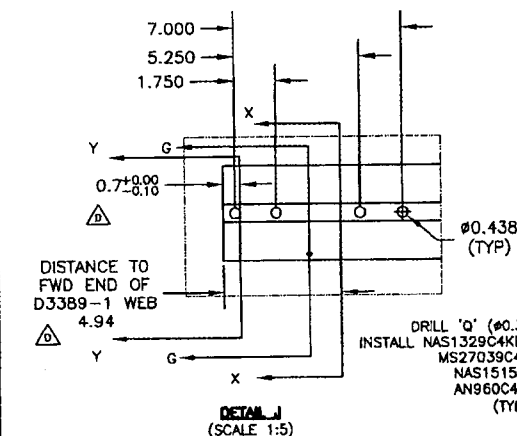
QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
4	4	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER
24	14	NAS1330C3KB166	INSERT

5 DRILL "E" (Ø0.250-Ø0.257) C'SINK (Ø0.391 X 100") INSTALL NAS1330C3KB166 (6 PLACES)

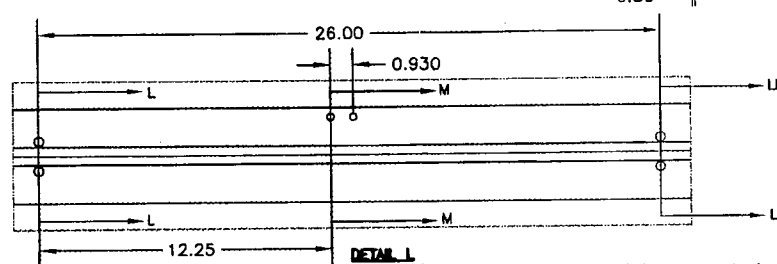
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DATE 06.04.25		TITLE 412 FLOAT SKIDTUBE		SHEET 2 OF 5	
				SCALE 1:10	



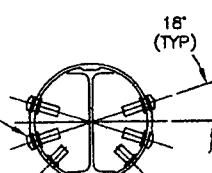
D3391-013 ASSEMBLY DETAIL



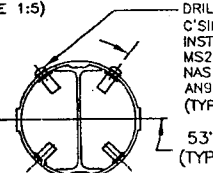
DETAIL J (SCALE 1:5)



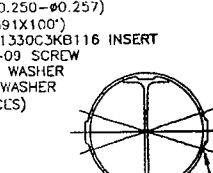
DETAIL L (SCALE 1:5)



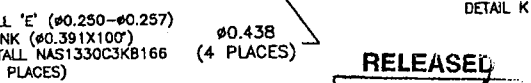
SECTION L-L (SCALE 1:4)



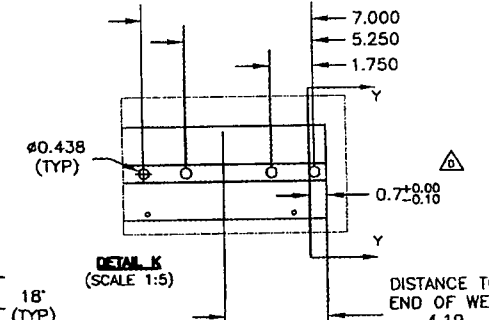
SECTION M-M (SCALE 1:4)



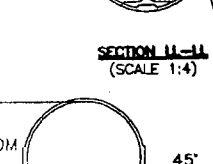
SECTION U-U (SCALE 1:4)



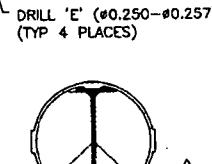
D3391-023 ASSEMBLY DETAIL



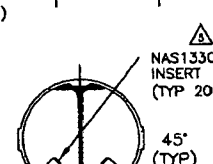
DETAIL K (SCALE 1:5)



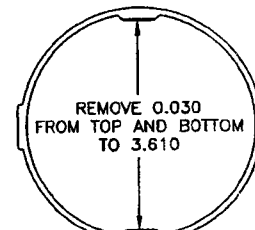
SECTION Y-Y (SCALE 1:4)



SECTION G-G (SCALE 1:4)



SECTION H-H (SCALE 1:4)



SECTION X-X (SCALE 1:2)

D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X	X	D3391-013	MID TUBE ASSEMBLY
		D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330C3KB116	INSERT
24	10	NAS1330C3KB166	INSERT
4		NAS1329C4KB140	INSERT
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

D3391-013/-023 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015

REMOVE 0.225 FROM TOP AND BOTTOM TO 3.800 (0.7 FROM BOTH ENDS)

SECTION Y-Y (SCALE 1:4)

SECTION G-G (SCALE 1:4)

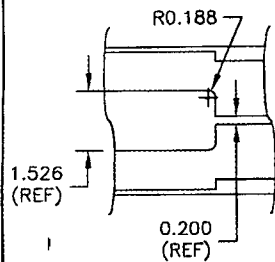
SECTION H-H (SCALE 1:4)

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		DATE 06.04.25	TITLE 412 FLOAT SKIDTUBE		SCALE 1:20

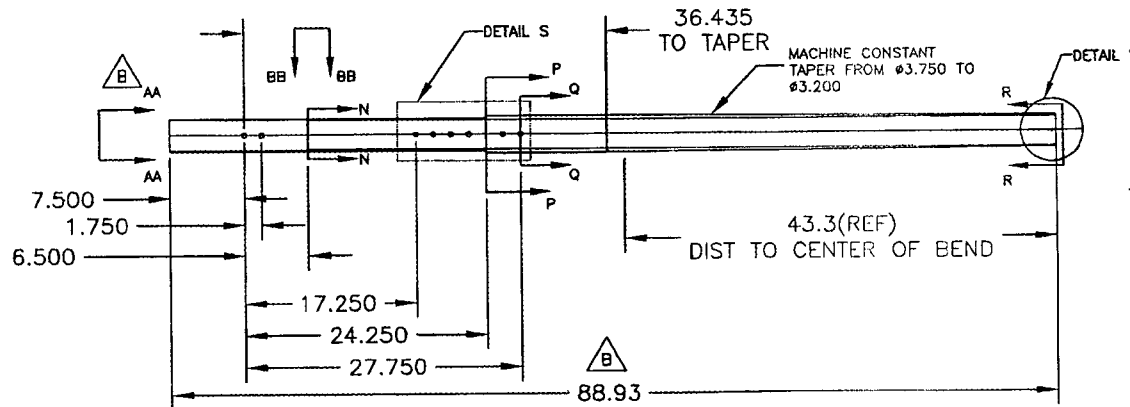
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06.05.01

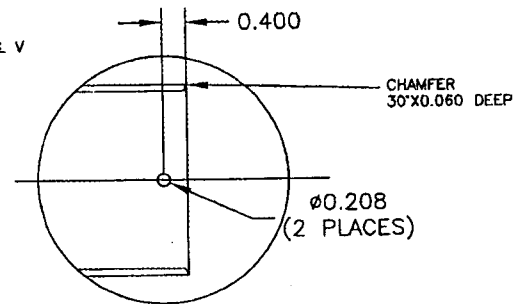
UNSUB REVIEW
07.04.10



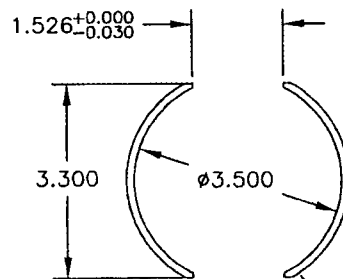
VIEW BB-BB
(SCALE 1:3)



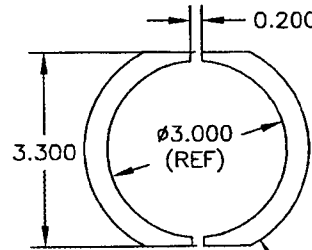
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



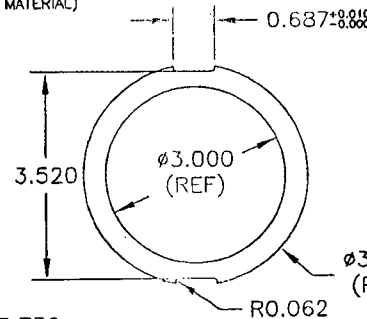
DETAIL V
(SCALE 1:2)



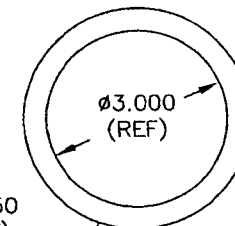
SECTION AA-AA
(SCALE 1:2)



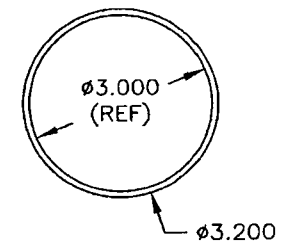
SECTION N-N
(SCALE 1:2)



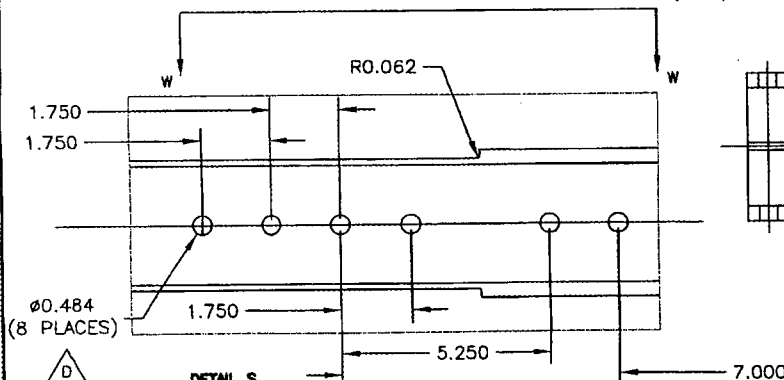
SECTION P-P
(SCALE 1:2)



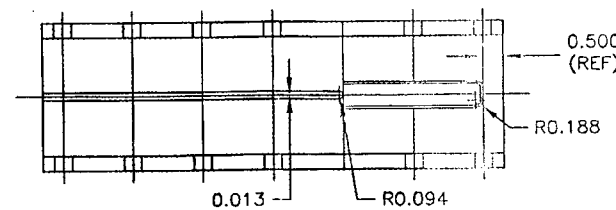
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



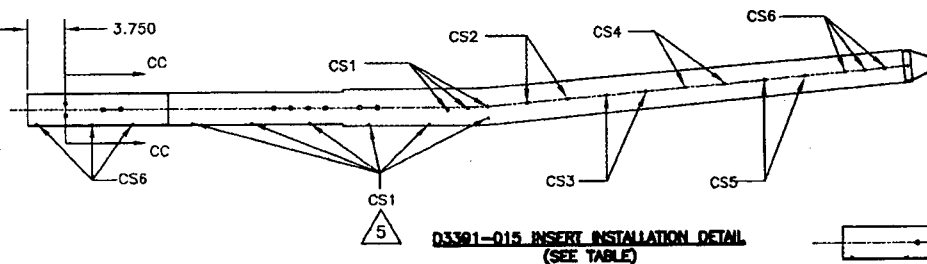
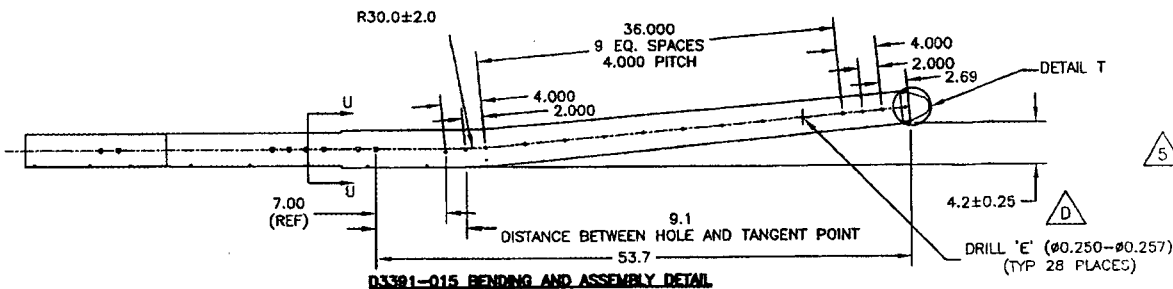
DETAIL S
(SCALE 1:3)



VIEW W-W
(SCALE 1:3)

UNDER REVIEW
07.01.15 DILL
PH 07.04.10
RELEASED
06.05.03

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				D3391	SHEET 4 OF 5
DATE	06.04.25	TITLE	412 FLOAT SKIDTUBE	SCALE	1:12

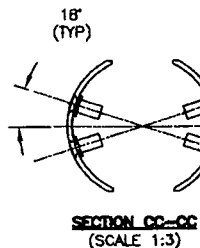


C'SINK AND INSTALL AESS10KBXXX AND/OR NAS1330C3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

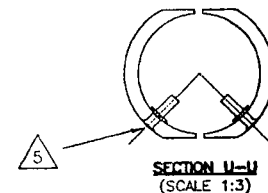
HOLE MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	AESS10KB366
CS2	2		Ø0.391	AESS10KB366
CS3	2	2	Ø0.291	NAS1330C3KE316
CS4	2	2	Ø0.391	NAS1330C3KE266
CS5	2		Ø0.391	NAS1330C3KE216
CS6	12	8	Ø0.391	NAS1330C3KE166

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

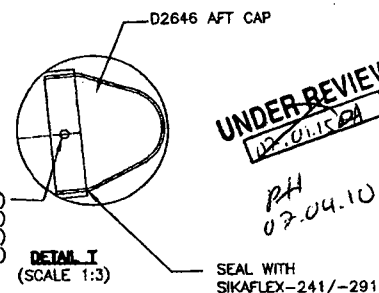
QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
18	14	AESS10KB366	INSERT
4	2	NAS1330C3KB316	INSERT
4	2	NAS1330C3KB266	INSERT
4		NAS1330C3KB216	INSERT
12	8	NAS1330C3KB166	INSERT
4		NAS1330C4KB151	INSERT
2	2	AN3C4A	BOLT
2	2	NAS1515H3L	WASHER
2	2	AN960C10L	WASHER



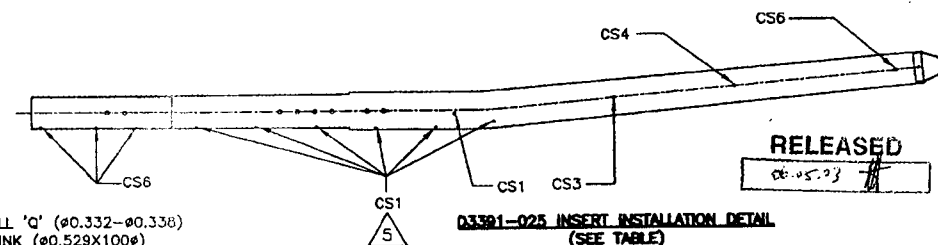
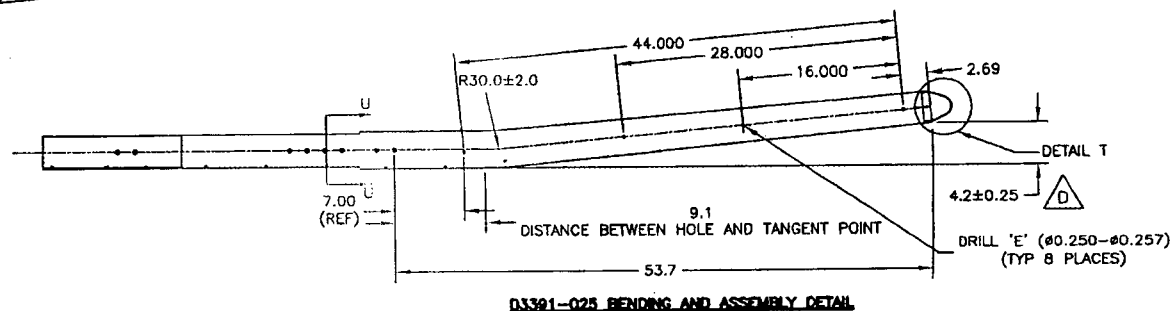
DRILL 'Q' (#0.332-#0.336)
C'SINK (#0.529X100#)
NAS1330C4KB151 INSERT (1)
(4 PLACES)



AN3C4A BOLT (1)
NAS1515H3L WASHER (1)
AN960C10L WASHER (1)
(2 PLACES)



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PH
07.04.10



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06.05.03

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CHECKED	APPROVED	DRAWING NO. D3391	SHEET 5 OF 5
DATE 06.04.25	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12	